



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3506-3
Job Sheet 179647



Part No: D3506-3

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/6/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 06-05-31 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	20 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Waterjet		du 18/06/22
100	Waterjet	20 pcs	7/6/18	7/6/18	0.00	0.71	Waterjet1		du 18/06/22
110	QC	20 pcs	7/6/18	7/6/18	0.00	0.00	QC2 Waterjet-2		du 18/06/22
120	CNC Vertical Machining	20 pcs	7/6/18	7/6/18	0.00	1.43	HAAS1-3		90mm 18/06/11
130	QC	20 pcs	7/6/18	7/6/18	0.00	0.00	QC2 Machining-2		11/18/07/13
140	QC	20 pcs	7/6/18	7/6/18	0.00	0.00	QC8 Machining-2		DAS 38
150	Small Fab	20 pcs	7/6/18	7/6/18	0.00	0.23	Small Fab-4		SA 18/07/13
160	QC	20 pcs	7/6/18	7/6/18	0.00	0.00	QC5		38
170	HandFinish	20 pcs	7/6/18	7/6/18	0.00	0.34	HandFinish1		SA 18/07/13
180	QC	20 pcs	7/6/18	7/6/18	0.00	0.00	QC7-2		38
190	Packaging	20 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		9-89
200	QC21-SA	20 Ea	7/6/18	7/6/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - 1-Cut as per Dwg D3506 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - Machine as per Folio FA640 and Dwg D3506

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - C'sink as per Dwg D3506 (On Flat side)

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1

180 - QC7-Inspect Chemical Conversion Coat

190 - Identify as per dwg & Stock Location: _____ LOCATION : LG001

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	.1560 sf (.0078 ea)	90-Start up Operation	5025678

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.100	0	44	0



Container No: S083326



Part: D3506-3

Job No: 179647

Serial No/Batch: S083326

Revision:

Inspector:

Exp Date:

Instructions:

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Date: 06/22/18

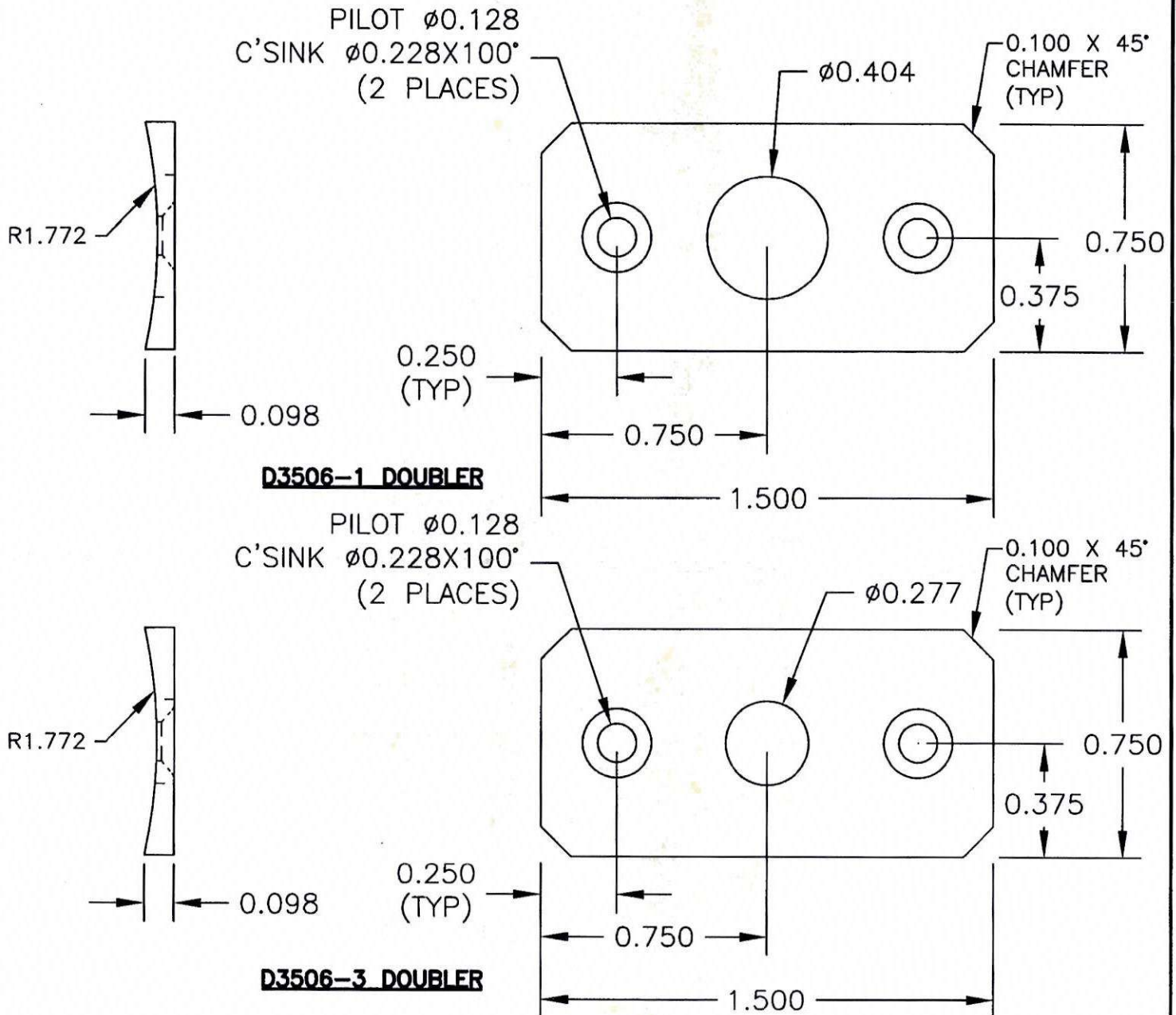
WV
SC
CAU
SC
SS-C
ZAC
FS
SS-C

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128inches + 0.005 - 0.001	0.133 0.127		
2	Doubler	0.277inches + 0.006 - 0.001	0.283 0.276		
3	Doubler	0.750inches ± 0.010	0.760 0.740		
4	Doubler	1.500inches ± 0.010	1.510 1.490		
5	Doubler	0.375inches ± 0.010	0.385 0.365		
6	Doubler	0.750inches ± 0.010	0.760 0.740		
7	Doubler	0.250inches ± 0.010	0.260 0.240		
8	Doubler	0.098inches ± 0.010	0.108 0.088		

Plex 6/20/18 1:44 PM dart.white.jesse

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED JH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21	TITLE DOUBLER		SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.10.02 PH
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